

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000207**Date Inspected:** 17-May-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China

Witness: **Procedure Qualification Record**
 Welding **NDT**

Welder Qualification **Fracture Critical**
Mechanical Testing, describe:

Index Lot #: B71-028-07a**Witness Lot #:** B71-028-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Han Chang Hou**ID #:** N/A**Joint Description:** B-U2-S

N/A

WPS ID #: PWPS-B-T-2221-U-2

N/A

Base Metal: A709M-Gr 50T-2

N/A

PQR ID #: HP200785

N/A

Thickness: 26 mm

N/A

Process: SAW

N/A

Electrode Spec/Class: AWS 5.17(H14)/EH14

N/A

Positions: 1-G

N/A

Backing Material: A709 Gr.50T-2

N/A

CWI: Huang Wei

N/A

Average Amps: 692.5

N/A

AWS Code: AWS D1.5 (2002)

N/A

Average Volts: 25.6

N/A

Applicable Sec: AWS 5.13

N/A

Travel Speed: 599.9 mm/min

N/A

Heat Input: 2.0 KJ/mm

N/A

Preheat: 20-230 Celsius

N/A

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector was present as requested to witness the welding of the Procedure Qualification Record(PQR) test plate HP 200785 using the submerged arc welding (SAW) electrode specification/classification A5.17(H14)/EH14, diameter of electrode 4.8 mm in the 1-G position. The welding was performed per the AWS D1.5, Section 5.13 Production Procedure WPS. Total of passes/layers were 17 passes and 8 layers. The welding on the 600 mm test coupon appeared to be in compliance with the contract documents.

Note: PQR HP200785 was performed on the ZPMC's fabrication shop using the Gantry SAW welding machine

Summary of Conversations:

The QA inspector did not have any significant conversations on this date.

is in general conformance with the contract requirements.

Observed welding,testing or results:

WELDING WITNESS REPORT

(Continued Page 2 of 2)

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: McClary,David

QA Reviewer